



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D5669-041
Job Sheet 193821



Part No: D5669-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/23/19

Job Tracking No:

Due Date: 5/10/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: TBD DWG D5669 REV.A IPP REV:A 18.07.23 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	5/10/19		0.00	6.67	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		DAS
							Large Fab - 6		43
							Large Fab - 7		9-89
							Large Fab - 8		
110	QC 9	1 pcs	5/10/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24	DAS 24	MAY 2 2 2019
							QC 9 - 43	9-89	
							QC 9 - 50		
120	QC 5	1 pcs	5/10/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24	DAS 24	MAY 2 2 2019
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		



Container No: S182314



Part: D5669 - 041

Job No: 193821

Serial No/Batch: S182314

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/18/19

			QC 5 - 30	
			QC 5 - 40	
130 Powdercoat - 2 White Gl(S)- B4B <i>M51744</i>	1 pcs	5/10/19	0.00 0.40	Powdercoat - 1 - B4B
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	
			Powdercoat - 4 - B4B	
			<i>START: 1:15 O.V.T: 375° FINISH: 1:30</i>	
135 QC 3	1 pcs	5/10/19	0.00 0.00	QC 3 - 10
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59 <i>VM AT</i>	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			140 Handfinish - 4-1-Assembly- B4B	1 pcs
Handfinish - 4 - 10 - B4B				
Handfinish - 4 - 11 - B4B				
Handfinish - 4 - 12 - B4B				
Handfinish - 4 - 13 - B4B				
Handfinish - 4 - 14 - B4B				
Handfinish - 4 - 15 - B4B				
Handfinish - 4 - 2 - B4B				
Handfinish - 4 - 3 - B4B				
Handfinish - 4 - 4 - B4B				
Handfinish - 4 - 5 - B4B				
Handfinish - 4 - 6 - B4B				
Handfinish - 4 - 7 - B4B				
Handfinish - 4 - 8 - B4B				
Handfinish - 4 - 9 - B4B				
150 QC 5	1 pcs	5/10/19	0.00 0.00	QC 5 - 10
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			<i>19</i>	
			<i>9-89</i>	
			</	

					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
160	Packaging 3-1 - Stock - B4B	1 pcs	5/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	DAS
					Packaging 3 - 35 - B4B	21
					Packaging 3 - 36 - B4B	9-59
170	QC 21 - SA	1 pcs	5/10/19	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-59

MAY 29 2019

MAY 29 2019

Part Op 100 - 1- Assemble ribs , weld as per dwg D5669 using DT9607A 2- Weld hinge (3) and Mounting brackets as per dwg
 Descriptions: D3914 ***Visual inspect before welding mesh*** 3- Cut lid mesh as per dwg 4- Tack weld mesh on basket as per dwg
 D5669 ***Cut out mesh where label plate goes in center off basket lid as per dwg. Make sure to place mesh correctly on
 lid, check with label plate before tacking mesh*** ***CUT OUT MESH ON TOP OF D2581 1.5" HIGH*** ***DOUBLE
 CHECK WITH A HANDLE*** 5- *****SCRIBE ID AS PER DWG NOTE 6 ON SHEET 1****
 110 - (QC9- Inspect visual per QSI004- Fusion Welds)
 120 - (QC5- Inspect part completeness to step on W/O) *****SCRIBE ID AS PER DWG NOTE 6 ON SHEET 1****
 130 - *** Mask holes as per note 9, sides of hinge and note 11 prior to powdercoat*** START TIME: _____ OVEN
 TEMPERATURE: _____ FINISH TIME: _____
 135 - (QC3- Inspect Part Finish)
 140 - (Assemble as per dwg) 1- Assemble as per dwg 2- Mask data plate and apply wing walk on outside surface of mesh
 as per dwg and QSI Wing Walk batch: _____
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Identify as per dwg & Stock Location: _____)
 170 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5178393
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5178172
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	5110937
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	5177490
D5670-1	Rib	4 pcs (4 ea)	100-Large Fab - Basket - 1	5177084
D5670-3	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	5177059
D5672-1	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5133197
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	4181089
AN3-14A	Bolt	4 Ea (4 ea)	140-Handfinish - 4-1-Assembly-B4B	5161920-1
AN3-16A	Bolt	2 Ea (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5157471-1
AN5-17A	Bolt	2 Ea (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5156672
D2530	Handle Weldment	1 pcs (1 ea)	140-Handfinish - 4-1-Assembly-B4B	5179132
D2535	Spring	2 pcs (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5154034
D2537	Bushing	2 pcs (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5123161
D3953-17	Gas Spring Spacer	2 pcs (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5179592
D3953-19	Gas Spring Bracket	2 pcs (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5184017
MS21042L3	Nut	6 Ea (6 ea)	140-Handfinish - 4-1-Assembly-B4B	5157462-1
MS21042L5	Nut	2 Ea (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5176461
NAS1149F0332P	Washer	8 Ea (8 ea)	140-Handfinish - 4-1-Assembly-B4B	5155976
NAS1149F0563P	Washer	2 Ea (2 ea)	140-Handfinish - 4-1-Assembly-B4B	5098031-6

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	25	0
	D3914-1	2	0	0
	D4016-3	3	69	0
	D4035-043	2	4	0
	D5670-1	4	4	0
	D5670-3	9	9	0
	D5672-1	1	5	0
	M304EX0.75-16F	32	1,048	0
140-Handfinish - 4-1-Assembly-B4B	AN3-14A	4	233	0
	AN3-16A	2	200	0
	AN5-17A	2	145	0
	D2530	1	6	0
	D2535	2	248	0
	D2537	2	114	0
	D3953-17	2	9	0
	D3953-19	2	8	0
	MS21042L3	6	3,426	0
	MS21042L5	2	703	0
	NAS1149F0332P	8	5,225	0
	NAS1149F0563P	2	353	0

Part Specifications

Specifications could not be found.

Plex 4/23/19 8:38 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					